

Work Order ID 86579

86579

Page 1

July-05-12 1:10:43 PM

Item ID: D2221 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 350 Basket Base
 Start Date: 7/05/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/27/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: CL Date: 12/07/05 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D2221	Rev H	

100 0.00

100 Large Fab

Large Fab

Memo 0.00

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
 3- tack weld mesh on basket as per dwg D2221
 A/R ER316 S.S. Rod Batch: 4118161

~~***PLEASE NOTE***
 IF MAKING -041A OR -043A:
 DRILL HOLES FOR GAS SPRING
 IN D3825-041 AS PER
 DSI 9473~~

110 0.00

110 QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo 0.00

Quality Control

12-09-10 1x

DAS 24 12-9-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00							
125 *125* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00							

Handwritten: 120 only

Handwritten: 1 0 BLD-9-11.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo 1- Plug holes prior to 1ST COAT: <u>11-20</u> START TIME: <u>400 OF</u> OVEN TEMPERATURE: _____ FINISH TIME: <u>11-50</u> ***** 2nd coat if necessary ***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.00				1X	0		M-F 12/09/11
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				1	0		DL 12-9-11

M121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

July-05-12 1:10:43 PM

Item ID: D2221

Accept

N900040100

Setup Start ***NS1***

Revision 1D:

Stop *NS2*

Item Name: 350 Basket Base

Start Date: 7/05/12 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 7/27/12 Req'd Qty: 1.00 * 1 *

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation Description

Set Up/
Ran Hours**Tool ID****Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

150

Identify as per dwg & Stock Location P300-607-041

89629

150

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

1 6 BL 129-11.

MLJ 12/09/12

MF
12-09-12

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

July-05-12 1:10:41 PM

Page 1

Work Order ID: 86579

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 7/05/12

Required Date: 7/27/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 KJ/JLM
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N 10.06.29 added pressure
 wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 Rib		Manufactured	No			100	Each	8.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		8							
				83907		8							
D2221-5 Rib		Manufactured	No			100	Each	21.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		19							
				83914		4							
				84793		15							
				WA006		2							
				67117		2							
D2221-7 Rib		Manufactured	No			100	Each	7.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		5							
				84762		5							
				WA006		2							
				81041		2							

¹ B86847 → 1x 12.09.03

² B84793 → 21 12.09.03

¹ B81041 → 1x 12.09.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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July-05-12 1:10:42 PM

Page 2

Work Order ID: 86579

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 7/05/12

Required Date: 7/27/12

Start Qty: 1.00

Required Qty: 1.00

D2232-3
Basket Hinge

Manufactured No

100 Each 27.0000

² ~~B86362~~ → 2x *W* 12.09.03

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	25	
82304	3	
85698	10	
86362	12	
WA005	2	
75581	2	

D2235-1
Basket Rib

Manufactured No

100 Each 20.0000

² ~~B86356~~ → 2x *W* 12.09.03

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	16	
78636	5	
81910	1	
85602	4	
86051	6	
WA005	4	
66895	4	

D2581
Mounting Bracket

Manufactured No

100 Each 61.0000

² ~~B86961~~ → 2x *W* 12.09.03

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	39	
82506	2	
83230	3	
85436	10	
85452	24	
WA005	22	
70766	2	
81253	1	
82897	19	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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July-05-12 1:10:42 PM

Page 3

Work Order ID: 86579
Parent Item: D2221
Parent Item Name: 350 Basket Base

Start Date: 7/05/12

Required Date: 7/27/12

Start Qty: 1.00

Required Qty: 1.00

D3442-1 Manufactured No 100 Each 17.0000
Shim

Location	Loc Qty	Loc Code
WA	17	
80788	17	

² B80788 → 2x *SY* 12.09.03

D3825-041 Manufactured No 100 Each 10.0000
Rib Assembly (Basket End)

Location	Loc Qty	Loc Code
WA	10	
83912	4	
83913	6	

² B87355 → 2x *SY* 12.09.03

D3826-041 Manufactured No 100 Each 6.0000
Rib / Gusset Assembly

Location	Loc Qty	Loc Code
WA	6	
81571	6	

² B87287 → 2x *SY* 12.09.03

D3827-041 Manufactured No 100 Each 11.0000
Rib Assembly (Inboard)

Location	Loc Qty	Loc Code
WA	5	
81038	5	
WA006	6	
72729	1	
84792	5	

¹ B81038 → 1x *SY* 12.09.03

D3832-1 Manufactured No 100 Each 3.0000
Mesh (Base)

Location	Loc Qty	Loc Code
WA	3	
85175	3	

¹ *SY* 12.09.12
B87842 → 1x
~~2x 1x~~

July-05-12 1:10:43 PM

Shop Packet Print

Page 3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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July-05-12 1:10:43 PM

Page 4

Work Order ID: 86579

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 7/05/12

Required Date: 7/27/12

Start Qty: 1.00

Required Qty: 1.00

D3833-1

Manufactured No

100

Each

24.0000

2

Mesh (Base End Face)

Location

Loc Qty

Loc Code

WA

12

77521

4

86314

8

WA035

12

81259

1

85697

11

12-09-12
B89208 → 2x

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Shop Packet Print

Page 4

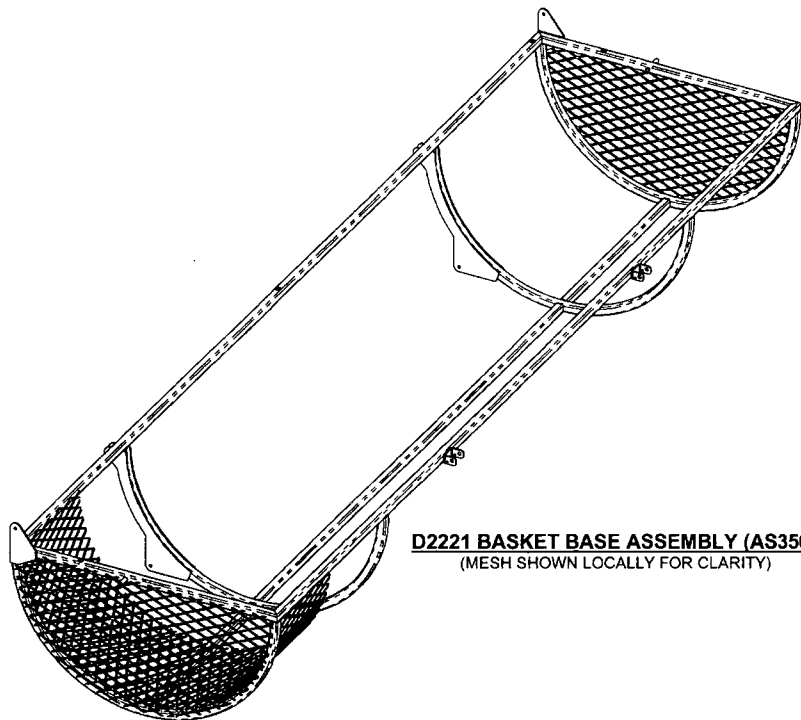
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D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

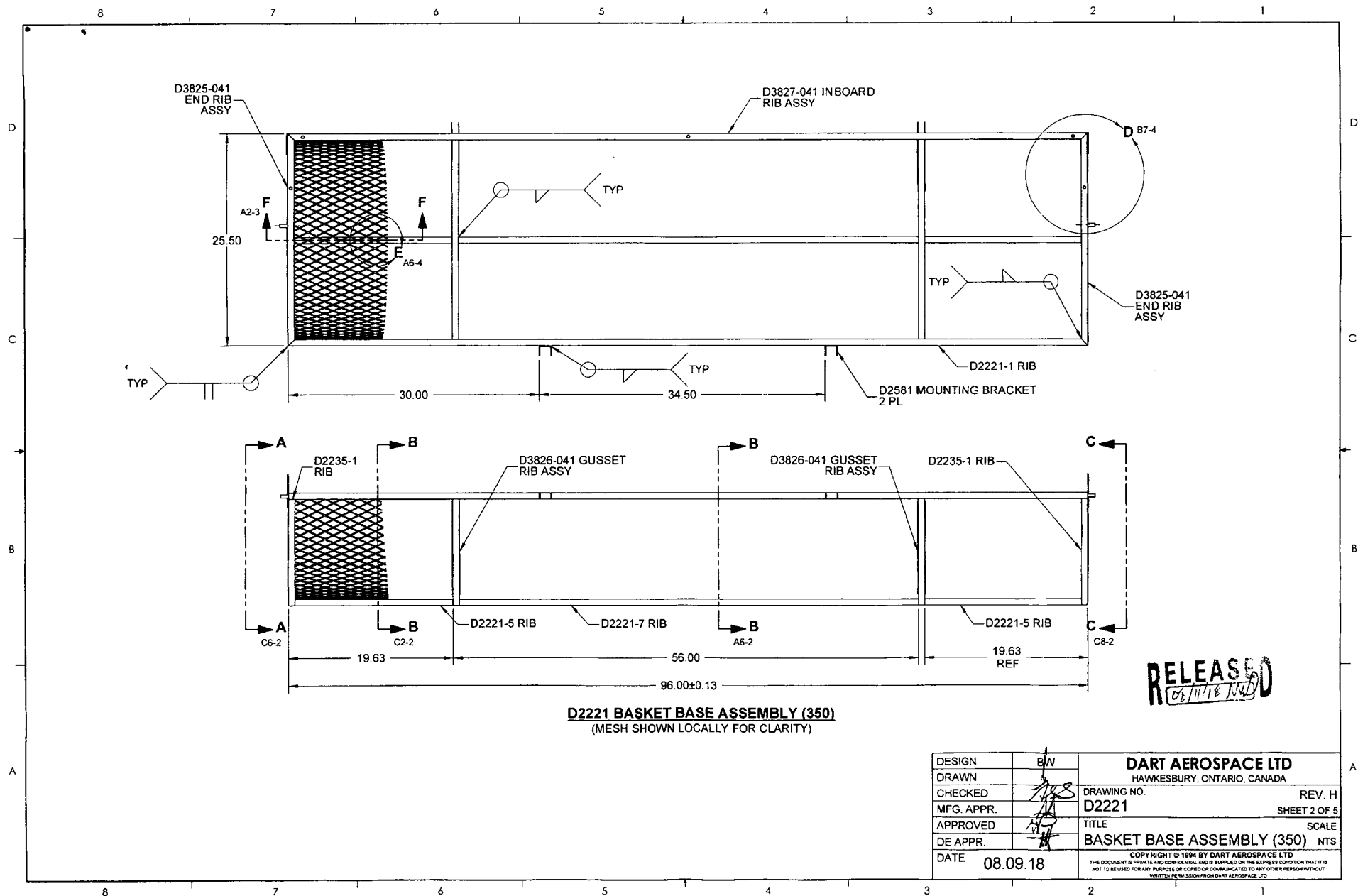
CL 12/07/05
W10. 86579

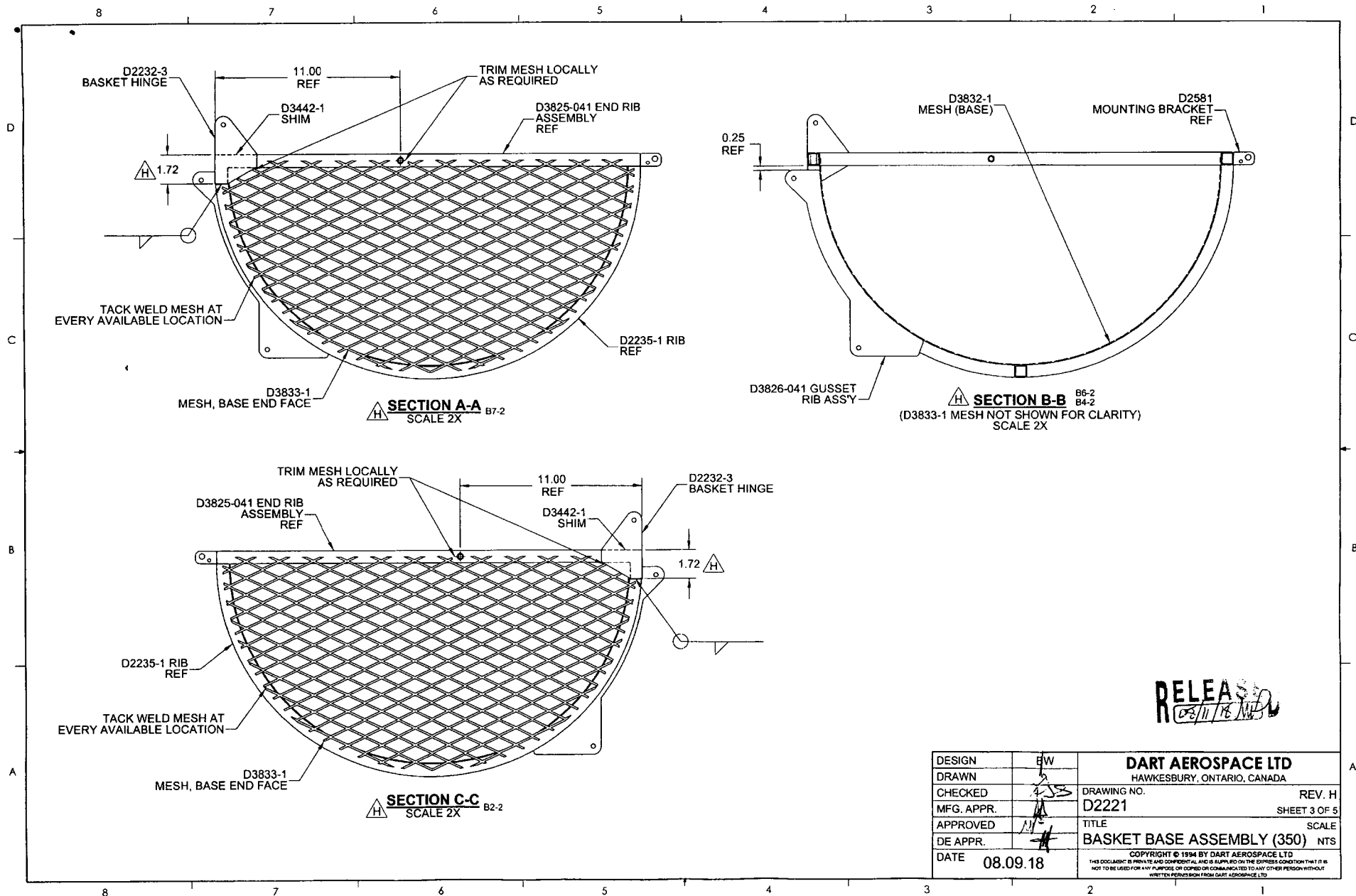


ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

RELEASED
08/11/18

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5/7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL. TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BW		
CHECKED	ASS	DRAWING NO.	REV. H
MFG. APPR.	ASS	D2221	SHEET 1 OF 5
APPROVED	WFO	TITLE	SCALE
DE APPR.	WFO	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

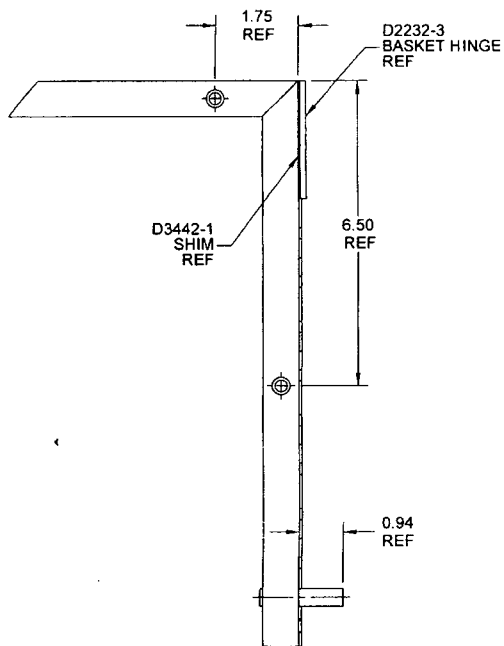




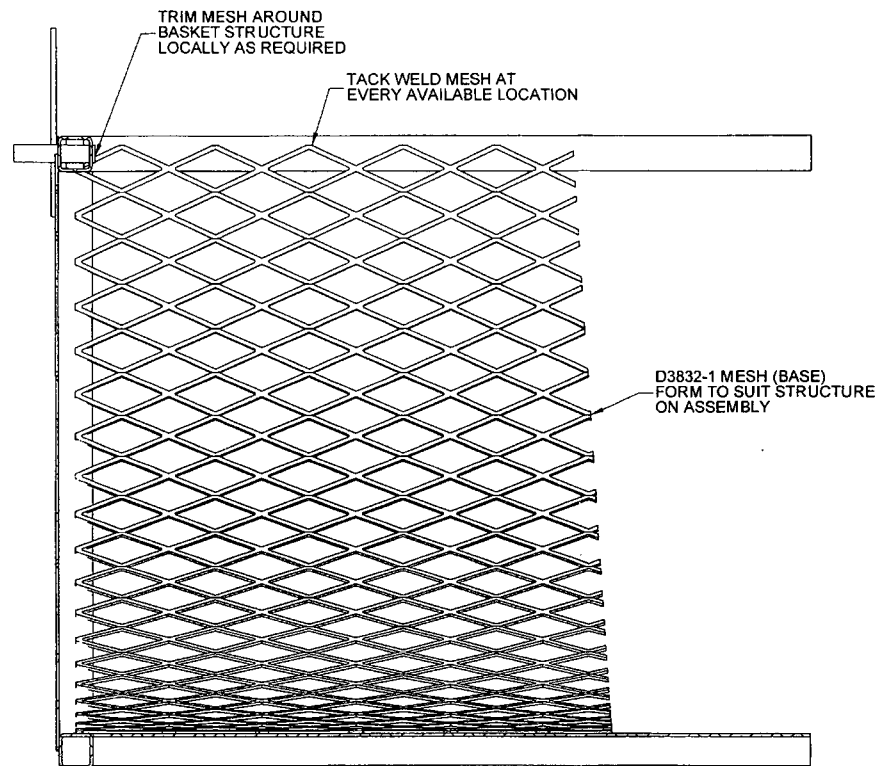
RELEASED
02/11/16

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	2	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SS	DRAWING NO. D2221	REV. H
MFG. APPR.	A	SHEET 3 OF 5	
APPROVED	MC	TITLE	SCALE
DE APPR.	H	BASKET BASE ASSEMBLY (350) NTS	
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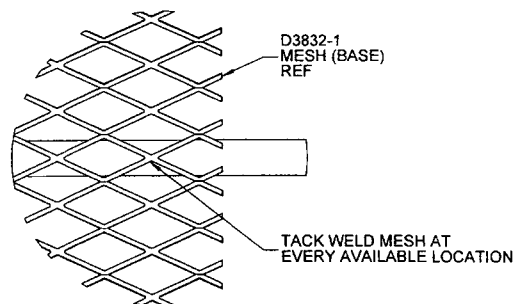
8 7 6 5 4 3 2 1



DETAIL D
SCALE 4X D2-2



SECTION F-F
SCALE 4X D7-2

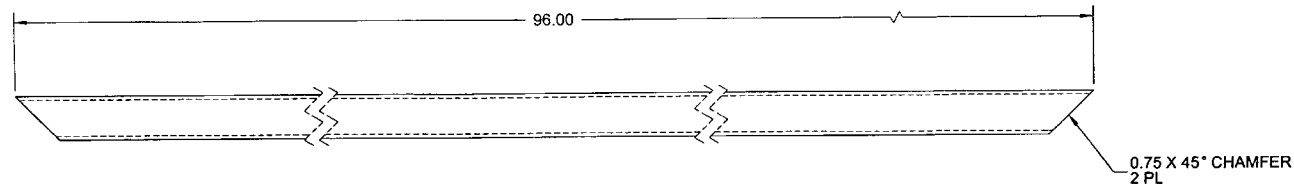
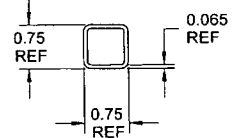
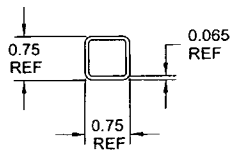


DETAIL E
SCALE 4X C6-2

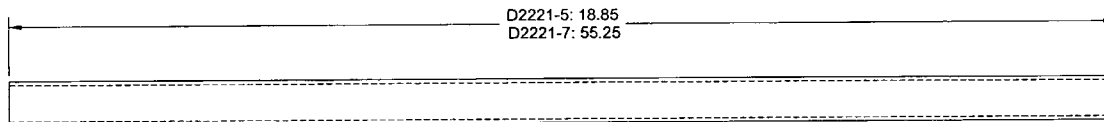
RELEASED
08/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D2221	REV. H
MFG. APPR.	<i>[Signature]</i>		SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1



D2221-1 RIB



D2221-5/-7 RIB

RELEASED
08/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. H
MFG. APPR.	MD	D2221	SHEET 5 OF 5
APPROVED	WJ	TITLE	SCALE
DE APPR.	SH	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR ADVERTISED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	